

Step 5 (cont.)

Procedure: (continued from previous page) Bore holes (hole saw may be used in lathe with pad on tailstock). Weld quartered pipe to sides. Layout and saw front piece. Bend an 8" length of $\frac{1}{4}$ " x 6" to the 7" template, scribe and saw to size. Weld ends. Use the $\frac{1}{2}$ " x $1\frac{1}{2}$ ", build foot and weld to base. Dress all welds. Drill the four $\frac{9}{32}$ " holes in foot.

Step 6

CAMSHAFT HOUSING and FOLLOWER BOSS: Sheet #1

Parts: #106 and #107

Materials: $1\frac{1}{2}$ " dia x 1" CRS., $\frac{3}{4}$ " dia x $\frac{3}{4}$ " CRS.

Procedure: Follow print.

Step 7

ASSEMBLY: Sheet #1

Drawing: #X14

Materials: Part #101 and #101-L mainbearing blocks, Parts #102/#103 hopper, Part #105 base, Part #106 and #107 camshaft housing and follower boss.

Welding Fixtures #X01, #X02, #X03, #X04, #X05, #X06, #X07

Procedure: Assemble Hopper (#102/#103) and mainbearing (#101 - #101-L) on welding fixture as shown. File as necessary to fit hopper to base. Clamp with #X07. Next use #X05 centering spud and bolt camshaft housing (#106) to fixture #X04. Follower boss #107 is also bolted to fixture. If necessary, file holes in base so fixture will bolt up without strain. Tack-weld hopper and bearing housing, then weld hopper to base on outside, mainbearing housing inside and outside, camshaft housing and follower boss on inside only. After welding the mainbearing housings, welds should be heated to red and let cool with the fixture in place. Any misalignment can be corrected by scraping the bushings.

